

Date: Wednesday, 4/5/2006 8:07:11 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 1/4 TURN FASTNER RAIL (BLACK)
Job Number : 26486	
Estimate Number : 10096	
P.O. Number : N/A	Part Number : D103858B
This Issue : 4/5/2006 S.O. No. : N/A	Drawing Number : D1038
Prsht Rev. : NC	Project Number : N/A
First Issue : 4/4/2006 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : N/A	Material : N/A
Written By : <i>See comment below</i>	Due Date : 4/21/2006 Qty: 80 Um: Each
Checked & Approved By : <i>06.04.04</i>	
Comment : Est: 03.05.02 Reformat; Added label KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
 Create white labels and bag them

2.0	D2023	Extrusion, Fastener Rail
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 80.0000 Each(s)
 Extrusion, Fastener Rail
 Batch: *21907*

J.F. 06/04/19 80

3.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut extrusion D2023 to length 21.81" (+0.06/-0.00)

J.F. 06/04/19 80

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine as per Folio and Dwg D1038-58

me 06/04/20 80

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

me 06/04/20 80

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MB

06/04/21

80

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

FB

06-05-01

80

8.0

OUTSIDE SERVICE

OUTSIDE SERVICES,



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: P.O. 1133

Black Anodize as per Dwg D1038

206105102 (80)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

P.O. 1133

80

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Anodize. Place in foam to protect anodize

06-05-11 80

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Stake .050 stainless steel wire per Dwg D1038-58 using DT8389

Batch: 14050

2-Grind wire flush and deburr

3-Clean

SAD 06-05-14

80

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-05-16 80

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-05-02	7.0	Add Q65 permanent change. <i>Z</i>					<i>Z</i>
		<i>Inspect Q65</i>	<i>Z</i>	06-05-02		<i>u</i>	
06-05-11	8.0 10.0	Anodize to mill spec Mil-A8625 F1 Type II Class 2 Add to steps 8 & 10. Mill spec should be written on the Dwg. Re P/O inspection. permanent change. <i>Z</i>				<i>u</i>	<i>Z</i> 06-05-11

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *PD* Date: 06/05/16 ⁷⁹
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-05-16	11	Part scrap. can end punched too hard and bent the corner, and dam- aged the mat'l.	<i>[Signature]</i>	Scrap: destroy	SAD 06-05-16	<i>[Signature]</i> 06-05-16	<i>[Signature]</i>	<i>[Signature]</i> 06-05-16

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

1-Pack each fastener rail into a cardboard tube

2-Taper ends to close cardboard tubes

3-Apply white labels to cardboard tubes

4-Identify and Stock

Location: FG47

EA

05.06.16

49

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP

06/05/16

79

Job Completion



U 06-05-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

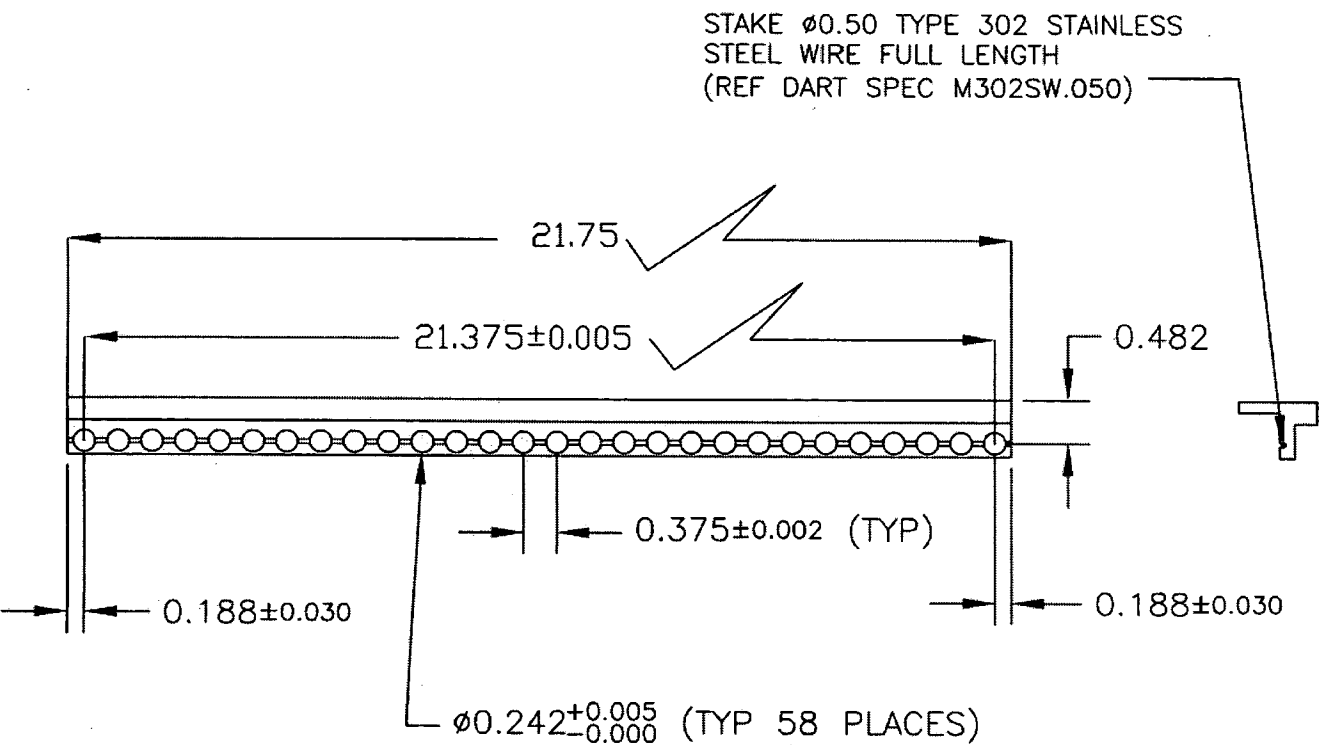
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED

05.03.31



DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
91	91	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
91	91	D1038	
DATE	TITLE		SCALE
05.02.02	1/4 TURN FASTENER RAIL		NTS
	NEW ISSUE		
	91.05.05		
A	04.05.14	UPDATE TOLERANCE	
B	05.02.02	REDRAWN, UPDATE NOTES	

D1038-58 1/4 TURN FASTENER RAIL

- 1) MAKE FROM D2023 EXTRUSION
- 2) FINISH: D1038-58 - NONE
D1038-58B - ANODIZE BLACK PER DART QSI 017 4.1.10
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26486

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TNM**ANODISATION et PEINTURE TNM INC.**

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / AS9100 certified

approuvé NADCAP approved

47556

08-May-2006

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE**CERTIFICAT DE CONFORMITE****PURCHASE ORDER/****NO. DE COMMANDE:****PO00001138**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
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1	80	80	D103-858-B AVIONICS FASTENER RAIL
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MATL: AL

BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filed and are available for viewing upon request.

Signature/Signed: ☐ Directeur de la Qualité / Q.A. Manager ☐ ☐